

Date: Tuesday, 07/04/2009 10:23:04 AM
 User: Julie Dawson

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : X-BOLT SPACER |
| Job Number : 46992 | |
| Estimate Number : 12321 | |
| P.O. Number : | Part Number : D34901 |
| This Issue : 07/04/2009 S.O. No. : | Drawing Number : D3490 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : MACHINED PARTS | Drawing Revision : A |
| Previous Run : 45338 | Material : |
| Written By : | Due Date : 20/04/2009 Qty: 40 Um: Each |
| Checked & Approved By : <u>JUD 09.04.07</u> | |
| Comment : Est Rev:A New Issue 06-03-03 JLM | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|------------------|-----------------------------|
| 1.0 | M6061T6T0500W049 | 6061-T6 RD Tube .500 x.049W |
|-----|------------------|-----------------------------|



Comment: Qty.: 0.2793 f(s)/Unit Total: 11.1720 f(s)

6061-T6 Tube .500 x.049W

(M6061T6T0.500W.049)

Batch: M111028

ml 09/04/12

(42)

| | | |
|-----|-----------------------------------|--------------------------|
| 2.0 | HARDINGE <u>DOOSAN</u> | HARDINGE CNC LATHE SMALL |
|-----|-----------------------------------|--------------------------|



Comment: ~~HARDINGE CNC LATHE SMALL~~

1-TURN AS PER FOLIO FA028 & DWG D3490

FOLIO REV: N/A

DWG REV: A

2-DEBURR AS REQUIRED

ml 09/04/11

(42)

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09/04/11

(42)

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| 4.0 | QC8 | SECOND CHECK |
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Comment: SECOND CHECK

B.A 09/04/13

(42)

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|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BATH

9/4/14

(42)

SU

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:23:04 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-BOLT SPACER

Job Number: 46992

Part Number: D34901

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/14 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09.04.14

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|--------------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 48992 |
| Description: Crossbolt Spacer | | Part Number: D3490-1 |
| Inspection Dwg: D3490 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

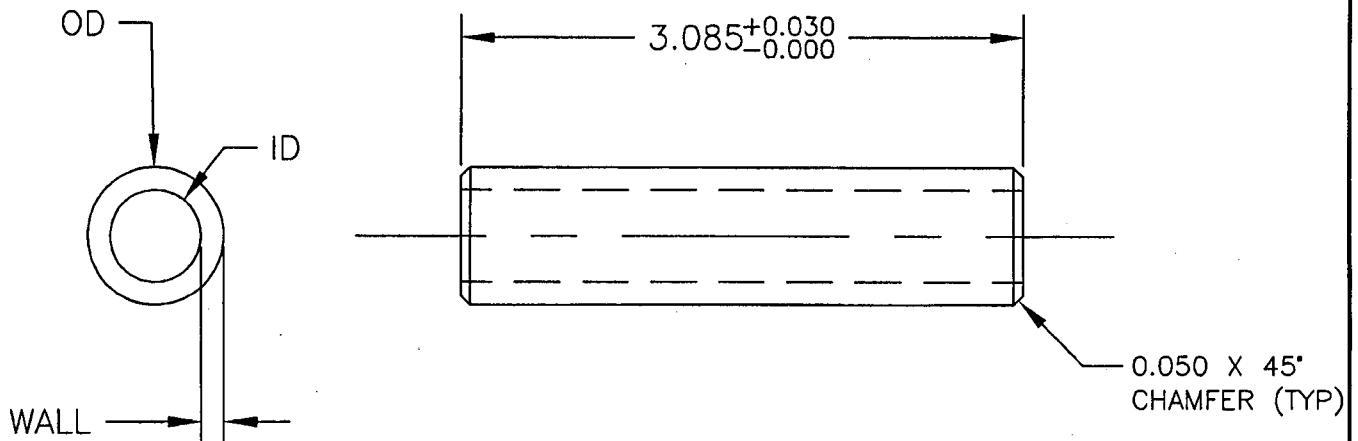
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.500 | +0.006/-0.001 | .499 | — | | | |
| 0.049 | +/-0.010 | .046 | — | | | |
| Ø0.402 | +0.006/-0.001 | .404 | — | | | |
| 3.085 | +0.030/-0.000 | 3.100 | — | | | |
| 0.050 x 45° | +/-0.010 | .045x45° | — | | | |
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| Measured by: JML | Audited by: D.A | Prototype Approval: | N/A |
| Date: 09/04/11 | Date: 09/04/13 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------------------|------------|----------|
| A | 06.10.06 | New Issue | KJ/JLM | |
| B | 08.06.02 | Dimensions and tolerances revised | KJ/DD | |
| C | 08.10.07 | 0.050 x 45° dimension revised | KJ/DD | |

DART

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|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>PH</i> | DRAWN BY <i>PH</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3490 | REV. A SHEET 1 OF 1 |
| DATE 06.01.04 | | TITLE CROSS BOLT SPACER | SCALE NTS |
| A | 06.01.04 | NEW ISSUE | |

**D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST**

| PART NUMBER | OD | WALL | ID (REF) | MATERIAL SPEC |
|-------------|-------|-------|----------|--------------------|
| D3490-1 | 0.500 | 0.049 | 0.402 | M6061T6T0.500W.049 |
| D3490-3 | 0.750 | 0.080 | 0.591 | M6061T6R0.750 |
| D3490-5 | 0.313 | 0.058 | 0.197 | M6061T6T0.313W.058 |

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *410912*

RELEASED
06-02-07

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